

91952

October-19-12 2:47:58 PM

N900040100

Setup Start *NS1*

Stop *NS2*

4

Start Date: 10/18/12 **Start Qty:** 4.00

Cust Item ID:

Required Date: 11/09/12 **Req'd Qty:** 4.00

4

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: MLJ Date: 12-10-22 Tooling:

Date: _____

Stop *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____

Date: _____

Draw Nbr	Revision Nbr
D2672	Rev B1

120 0.00

120

FLOW WATER JET

Waterjet	Memo	0.00
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FLOW CNC Waterjet

130	0.00
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130

HAAS CNC VERTICAL MACHINING #1

HAAS 1	Memo	0.00
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HAAS CNC vertical machine #1

Memo

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio FA791 and Dwg D2672. Identify as D2672
3-Deburr

140	QC2- Inspect parts off machine FAI/FAIB	0.00
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140

QC	Memo	0.00
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Quality Control

Memo

(4) BIL-10-26

PO. 12/10/30 7 0

PO 12/10/30 4 ~~0~~

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		

Work Order ID 91952

91952

Page 2

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Item ID: D2672

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bearpaw 13" X 24", 206

Start Date: 10/18/12 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/09/12 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start *NR1*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC8- Inspect parts - second check

0.00

B.A 12/10/31

4

0

DAS
08
9-89

150

QC

Memo

0.00

Quality Control

180

Identify as per dwg & Stock Location:

0.00

Packaging

180

Packaging

Memo

PP191849

0.00

Packaging

12/11/15

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

12/11/15
MCS 12-11-02

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Picklist Print

October-19-12 2:47:58 PM

Work Order ID: 91952

Parent Item: D2672

Parent Item Name: Bearpaw 13" X 24", 206

Start Date: 10/18/12

Required Date: 11/09/12

Start Qty: 4.00

Required Qty: 4.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10 UHMW 1" Black		Purchased	No			120	sf	316.2575	3.6	14.4		12-10-2012	

Location	Loc Qty	Loc Code
MAT018	297.41	
118814	0	
121346	26.1	
121954	9.8	
122286	14.3	
122575	23.8	
122722	76.41	
123229	147	123229
ST052	18.84749474	
121277	12.8	
121278	6.04749474	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

DART AEROSPACE LTD		Work Order:	91952
Description: Bearpaw		Part Number:	D2672
Inspection Dwg: D2672 Rev: B1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	23.750	+/-0.030	23.750	✓		M. TAPE	P410-11
B	12.750	+/-0.030	12.750	✓		"	"
C	4.250	+/-0.010	4.253	✓		VERN	P410-01
D	2.000	+/-0.030	1.995	✓		"	"
E	9.000	+/-0.010	9.000	✓		"	CNC-02
F	0.375	+/-0.030	.377	✓		"	P410-01
G	9.000	+/-0.010	9.000	✓		"	CNC-02
H	Ø0.260	+0.005/-0.000	.260	✓		"	P410-01
I	Ø0.93	+/-0.030	.930	✓		"	"
J	0.300	+0.030/-0.000	.312	✓		MIC	P410-09
K	0.625	+/-0.030	.626	✓		VERN	P410-01
L	0.063 x 45°	+0.030/-0.010	.073	✓		"	"
M	0.250	+/-0.010	.245	✓		MIC	P410-02
N	5.500	+/-0.030	5.503	✓		VERN	P410-01
O	R0.250	+/-0.030	.250	✓		R-6.	
P	0.200	+/-0.030	.188	✓		MIC	P410-09
Q	0.25 x 45°	+/-0.030	.25	✓		M. TAPE	P410-11
R	0.950	+0.030/-0.010	.950	✓		VERN	P410-01
S	0.375	+/-0.010	.377	✓		MIC	118-120

Measured by: PD	Audited by: DAS	Prototype Approval:	N/A
Date: 12/10/30	Date: 12/10/31	Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	KJ/RF	

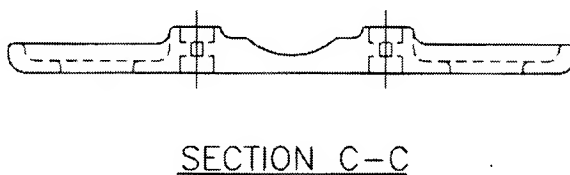
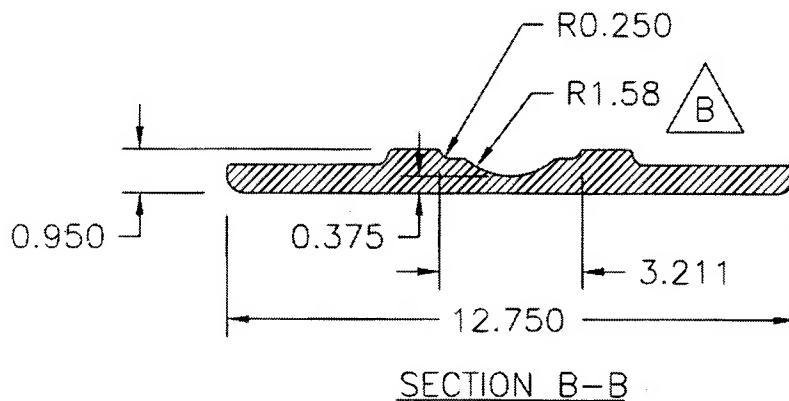
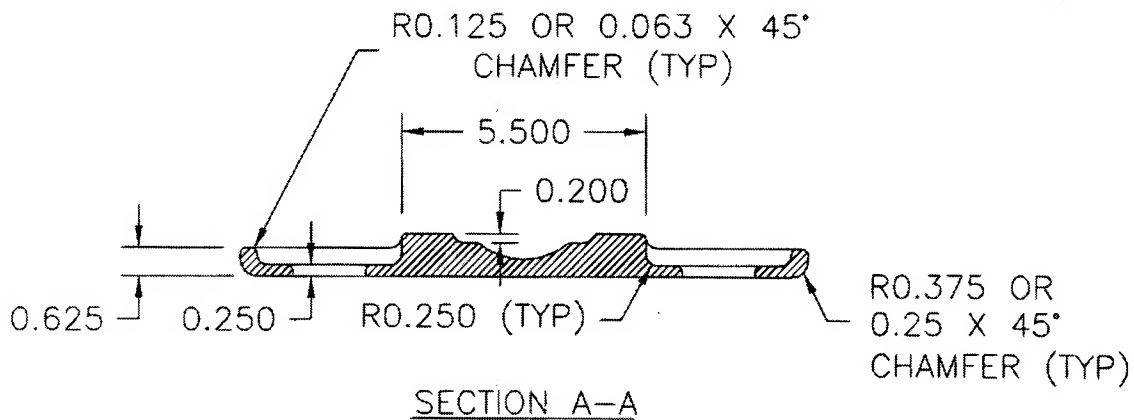
12-10-22

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DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED B.M.	APPROVED [Signature]	DRAWING NO. D2672	REV. B SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED
98.06.17 KE



91952